

Date: Thursday, 3/30/2006 10:06:02 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET  
 Job Number : 26451  
 Estimate Number : 10010  
 P.O. Number : N/A Part Number : D27353  
 This Issue : 3/30/2006 S.O. No. : N/A Drawing Number : D2735 REV C  
 Prsht Rev. : NC Project Number : N/A  
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : C  
 Previous Run : 25867 Material : N/A  
 Written By : SEE COMMENT BELOW Due Date : 4/12/2006 Qty: 40 Um: Each  
 Checked & Approved By : 06.03.30  
 Comment : Est Rev: C Removed from 9 Digit 05-10-25 JLM

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description:

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 00000926

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per Dwg D2735

Possible supplier: Ind. Laser

Material release note is required.

2.0 D27353F Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 40.0000 Each(s)

Lug Bracket

3.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material certification is attached

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per templates D2735-1T1 &amp; DWG D2735

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

2-Deburr if required.

SRB 06/05/15 41

SAD 06:05:15 41

W/O:

## WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	App QC Insp

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: LD Date: 04/05/25

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:

## WORK ORDER NON-CONFORMANCE (NCR)

DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: LUG BRACKET

Job Number: 26451

Part Number: D27353

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



*06-05-16* (41)

Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WS*

*06/05/24* (41)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/05/25* (41)

Job Completion



*06-05-25*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

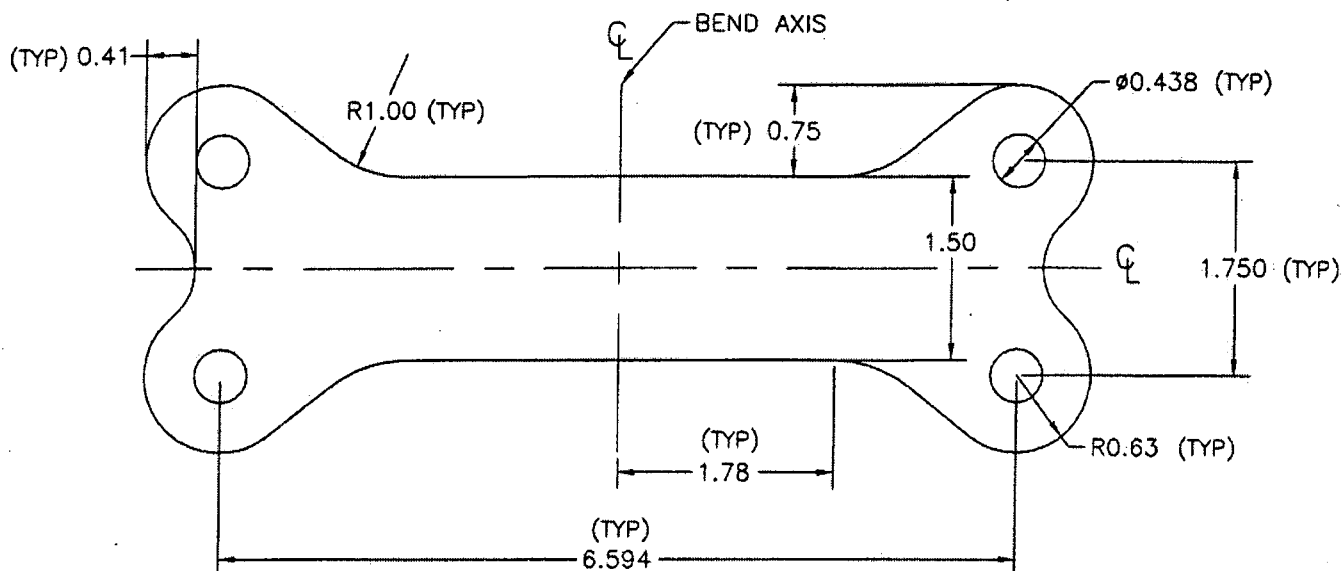
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

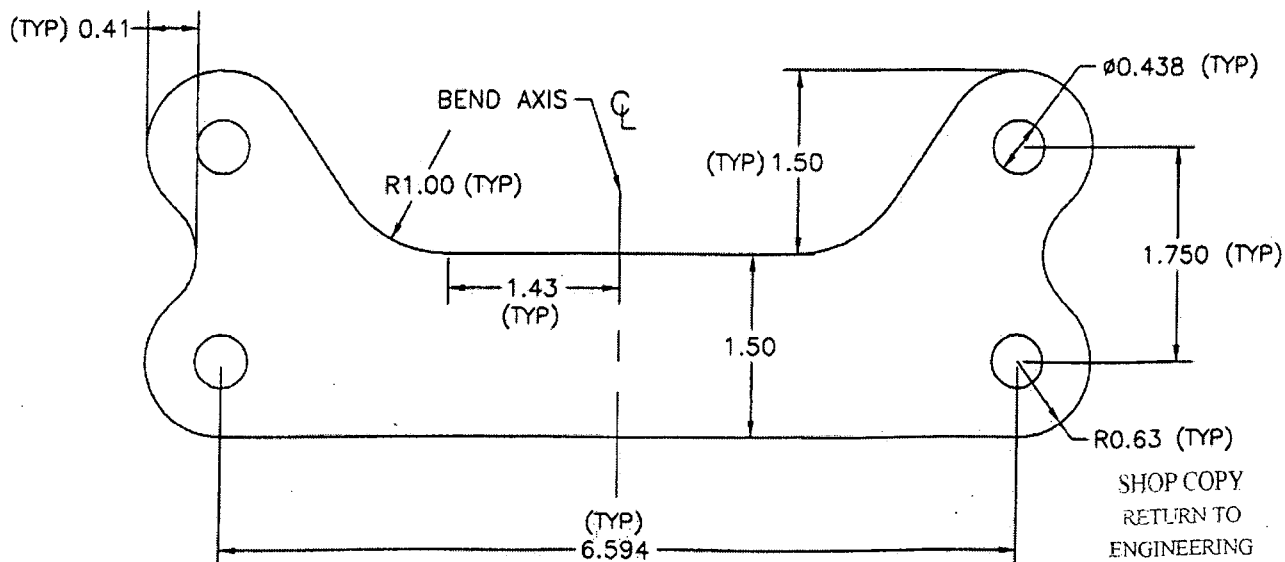


DESIGN <i>[initials]</i>	DRAWN BY <i>[initials]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED  
98.12.14 DS



D2735-1 FLAT PATTERN  
SYMMETRIC ABOUT BOTH CENTRE-LINES (CL)



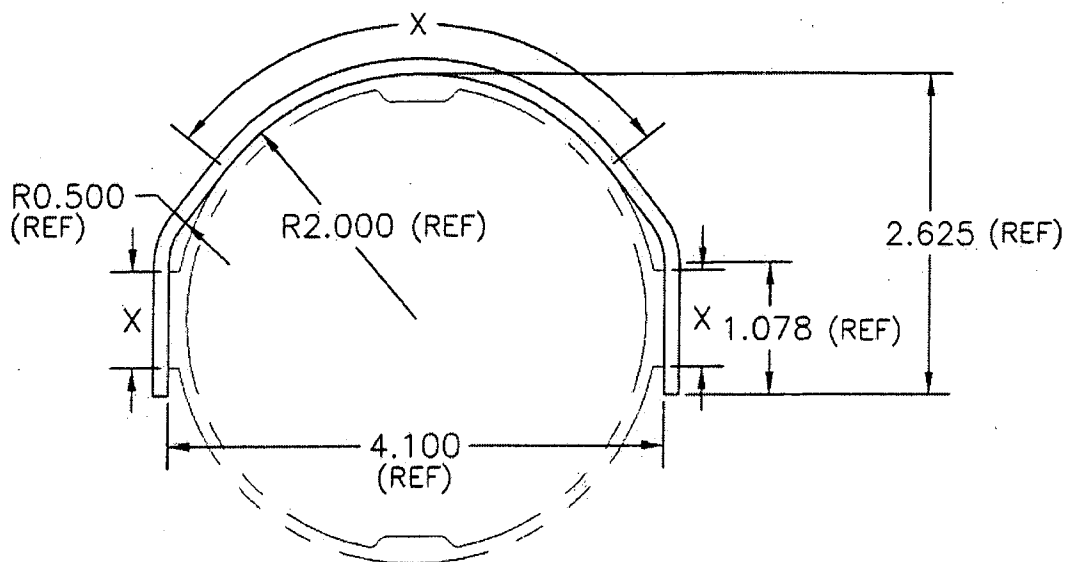
D2735-3 FLAT PATTERN  
SYMMETRIC ABOUT CENTRE-LINE (CL)

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
*26451*



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED  
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL  
0.125 THICK (11 GAUGE)  
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi  
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

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WORK ORDER  
NO. 26451



New Zealand Steel Limited  
 Glenbrook, South Auckland  
 Postal: Private Bag 62121, Auckland, New Zealand  
 Telephone: (09) 375 9999 / 375 9111 Auckland  
 (09) 235 9089 / 235 3535 Waikato  
 Fax: (09) 375 9999

# TEST CERTIFICATE

Ref: 374622104

Issued 1/12/2005

CUSTOMER		WILKINSON		P509160001		SPECIFICATION		ASTMA1808 CS Type A		CERTIFICATE No		TC122435												
CUSTOMER Q/N		99-31N-963				PRODUCT		CRA WIDE COIL		PAGE		1 of 1												
MILL Q/N		507683				DIMENSIONS		0.114" x 48" x CoR		DATE		29 November 2005												
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT														MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)								
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	GEI	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100				x1000										x10000		x100	180°				GL =	HRB
R9-471775-00	644609	6	TR	18	8	11	11	17	23	1	6	1	1					Good				51		794
R9-471776-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1					Good				51		682
R9-471777-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1					Good				54		768
R9-471778-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1					Good				54		640

YIELD	GUAGE LENGTH (G.L.)	PLASTIC STRAIN RATIO (r)	IMPACT TEST	CARBON EQUIVALENT VALUE (CE)
(A)=0.2% PROOF STRESS	(A)=200mm (C)=90mm (E)=2"	(A)=r0 (C)=r45	(A)=10mm x 10mm (B)=7.5mm x 10mm	(A)=C+Mn/6
(B)=LOWER YIELD STRESS	(B)=50mm (D)=5.65; So (F)=8"	(B)=r0 (D)=r0+r90+2r45 / 4	(C)=5mm x 5mm (D)=2.5mm x 10mm (E)=8mm x 10mm	(B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15
				(C)=C+Mn/6+8/24 (D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED  
 WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

*Datish Miera*  
 QC METALLURGIST